

Work Order ID 85862

85862

Page 1

June-18-12 10:49:49 AM

Item ID: D2012-107

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clevis

Start Date: 15/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2012-107	Rev C

20

100 FLOW WATER JET 0.00

100

Waterjet

Memo

0.00

B12-6-21

FLOW CNC Waterjet

1-Cut as per Dwg D2012-107

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

304, 063

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.00

B12-6-21

Quality Control

120 QC8- Inspect parts - second check 0.00

120

QC

Memo

0.00

20

W 12.06.21

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Accept

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Revision ID:

Stop *NS2*

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Start Date: 15/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 12.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/26

MF 12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

June-18-12 10:49:53 AM

Page 1

Work Order ID: 85862

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Parent Item: D2012-107

D2012-107

Parent Item Name: Clevis

Start Date: 15/06/2012

Required Date: 02/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: D 01.11.08 Re-format, Drawing to Rev. CSM
IPP Rev:E Now on Waterjet 06-06-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		110	sf	44.8846	0.016	0.202105	1.		

M304S16GA

**

1812-6-21

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

44.884633

121889

44.884633

121889

20

Dart Aerospace Ltd

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Dart Aerospace Ltd

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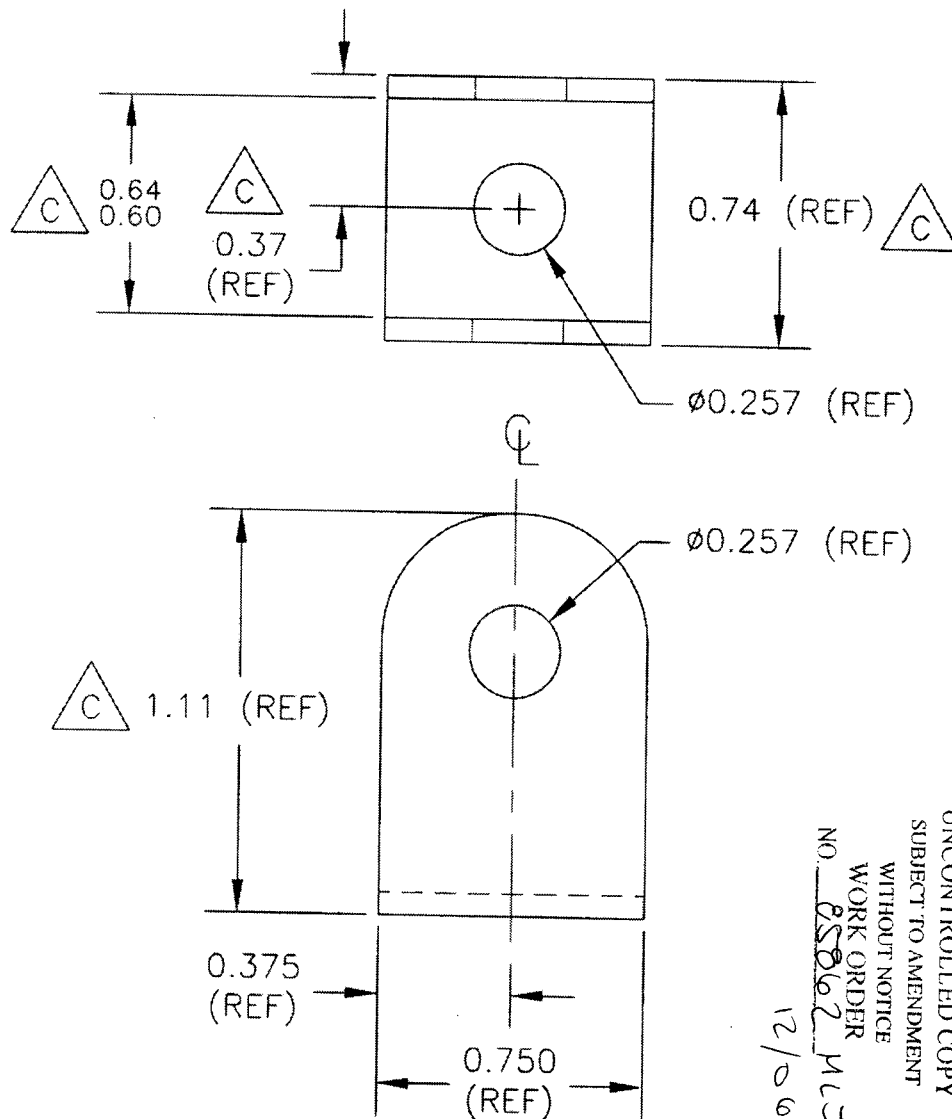
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DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 1 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	99.04.30	ADD FLAT PATTERN	
C	99.12.20	0.74 WAS 0.680	

RELEASED
CC 01.04 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85062 MLC
12/06/18

MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
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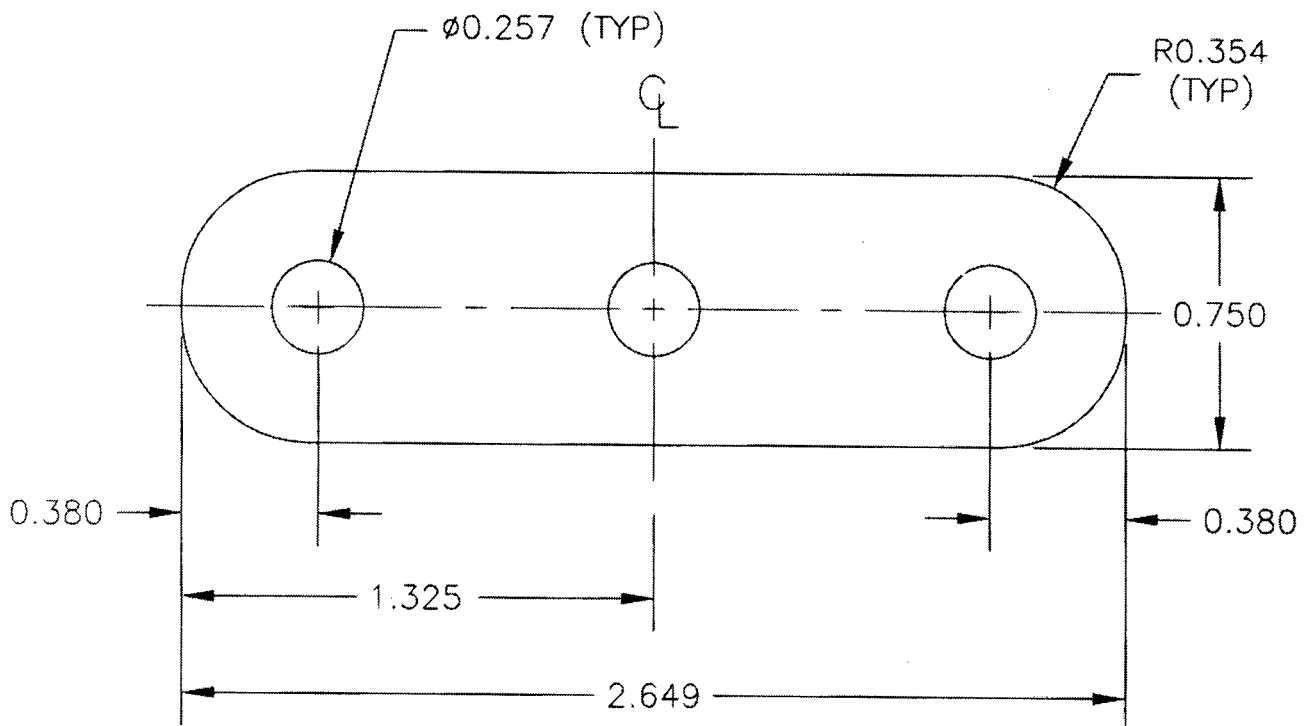
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1

RELEASED
00 01-04 DS



D2012-107 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

05862

Dart Aerospace Ltd

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